

DART SERVICE INSTRUCTION

TO AMEND INSTRUCTIONS FOR CONTINUOUS AIRWORTHINESS ICA-D206-667 Rev. 3 OR LATER
REF. CANADIAN STC: SH01-5
REF. FAA STC: SR01304NY
REF. EASA STC: EASA.IM.R.S.01179

PURPOSE:

The center support on the D407-667-205 Crosstube @ CHG 008 is now installed using Scotch-Weld instead of Magnobond:


CHANGE:

For the D407-667-205 crosstube @ CHG 008, section 32.4 of ICA-D206-667 is amended as follows. Use Figure 1 of this service instruction and Figures 32-9 of ICA-D206-667 for further reference. For crosstubes of an earlier change number, it is recommended that if the support is removed, the support should be reinstalled using the procedure listed below.

32.4 SUPPORT INSTALLATION

- 32.4.1 Locate the area on the crosstube for installation of support (see Figure 1 of this service instruction). The D2894-1 Support should be centered. Ensure paint finish of crosstube is intact; touch up as required per Chapter 5 (5.3.9) of ICA-D206-667.
- 32.4.2 If present, remove any paint/primer on bottom of supports. Abrade mating surfaces of support with 400-grit sandpaper. Abrade mating surface of crosstube with 180-grit sandpaper. Saturate a clean cloth with MEK or 4105S Wash'n'Wipe Degreaser or equivalent and wipe until there is no residue.
- 32.4.3 Apply a 0.04" to 0.07" thick layer of 3M DP460 Scotch-Weld Epoxy Adhesive underneath applicable support and install support as shown in Figure 1 of this service instruction.
- 32.4.4 Install the clamps opposite to crosstube support as shown in section A-A of Figure 1. Install rubber cushions underneath each clamp around the bottom circumference of the crosstube up to the crosstube centerline. Torque clamps 80-100 in-lb (9.0-11.3 Nm). It is acceptable to use smaller or larger sized MS21920-XX clamps than those listed in ICA-D206-667. Ensure that after torquing the clamps per this instruction, the nuts are in safety but not bottomed out
- 32.4.5 Prior to installing crosstube on aircraft, allow supports to cure for 24 hours and recheck torque on clamps.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: 
D. SHEPHERD (DE # 02)
DATE: 11.09.07
CERT. NO.: SH01-5
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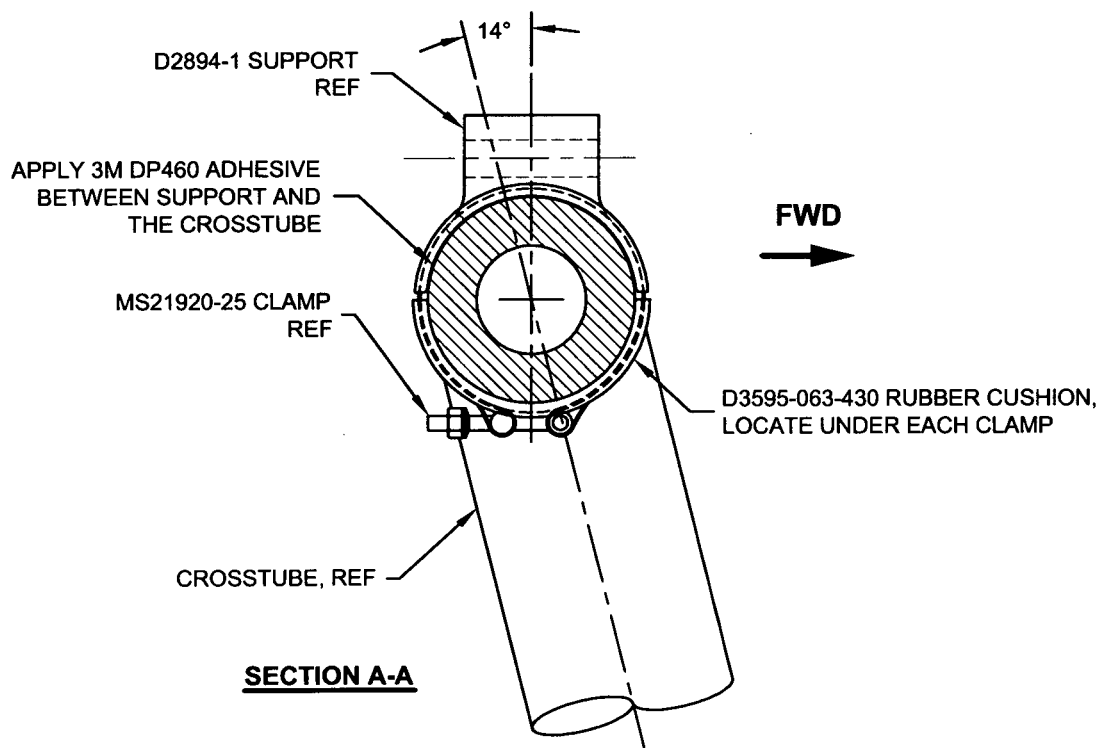
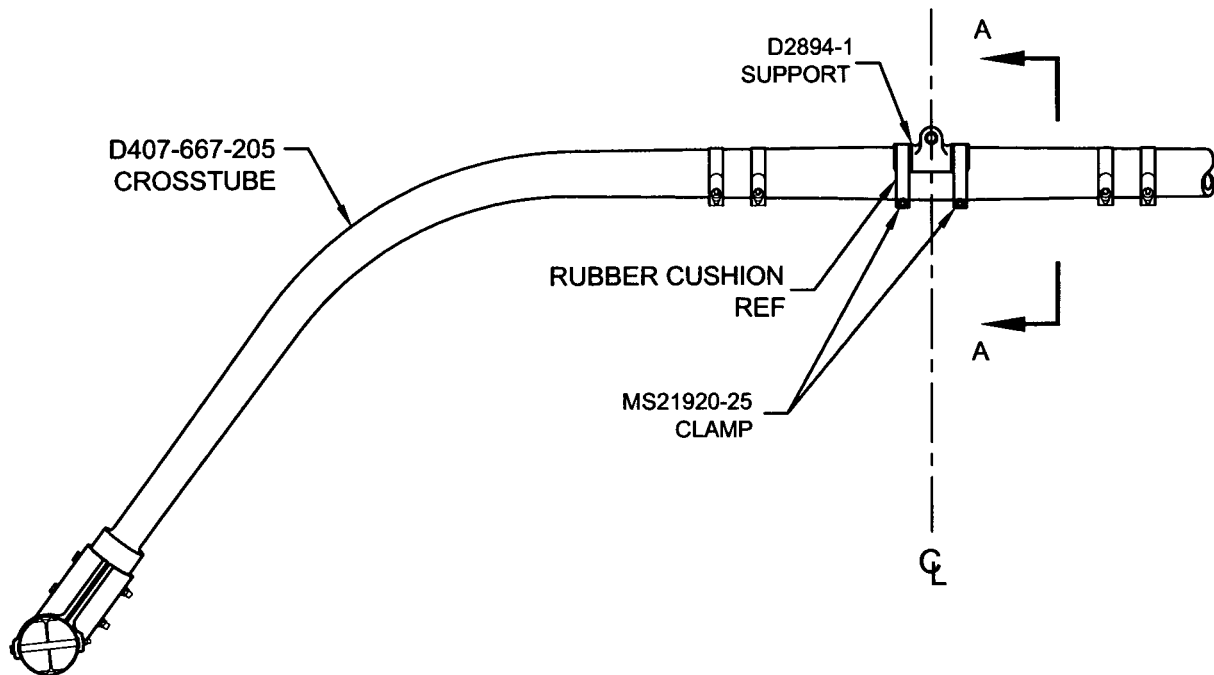


FIGURE 1: SUPPORT INSTALLATION

CANADA
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